



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83104**

Thursday, April 12, 2012 4:01:47 PM

**\*83104\***

Page 2

Item ID: D3937-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Luminescent Strip Assembly

Start Date: 4/12/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				(16)			
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00				16✓	4		11/12/58
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>						31			FF
Small Fab	Memo	0.00							13-04-30
Small Fab	1- Align part edges and stick strip to D3937-3 as per dwg								

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**NOTE:** Date & initial all entries

# Work Order ID 83104

Thursday, April 12, 2012 4:01:47 PM

**\*83104\***

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Item ID: D3937-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Luminescent Strip Assembly  
 Start Date: 4/12/2012 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 4/26/2012 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS B430				31 can			
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST074</u>  Memo	0.00 0.00				31x		80 13-430	
180 <b>*180*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						13/05/03	

13-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Thursday, April 12, 2012 4:01:52 PM

Work Order ID: 83104

\*83104\*

Parent Item: D3937-041

\*D3937-041\*

Parent Item Name: Luminescent Strip Assembly

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3937-1		Manufactured	No				Each	20.0000		16			
										**			
											Sp 13/04/29		
*D3937-1*													
Luminescent Strip													

Location	Loc Qty	Loc Code
ST072	17	B 94531
77627	17	
ST094	3	
73537	3	

M6061T6S.032		Purchased	No				100	sf	304.1560	0.09099	1.532463		
										**			
											(16)		
*M6061T6S 032*													
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code
MAT021	304.156	
118106	48.606	
120218	33.77	
120285	43.68	
121099	178.1	

1.532463

FF  
12-05-07

Sp 13/04/29

B 89647

\*D3937-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83104

*PL 12-041-R*

PEEL SELF-ADHESIVE BACKING FROM  
D3937-1 LUMINESCENT STRIP.  
ALIGN PART EDGES AND STICK TO  
D3937-3 SHEET METAL BACKING STRIP

**D3937-041 LUMINESCENT STRIP ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

**RELEASED**  
2009-12-02  
*MD*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE C5 19.5 DIM WAS 21.0 REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		<i>[Signature]</i>	09.06.02
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>[Signature]</i>		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>		D3937	SHEET 1 OF 3
MFG. APPR.	<i>[Signature]</i>		TITLE	SCALE
APPROVED	<i>[Signature]</i>		LUMINESCENT STRIP	NTS
DE APPR.	<i>[Signature]</i>		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.11.27			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

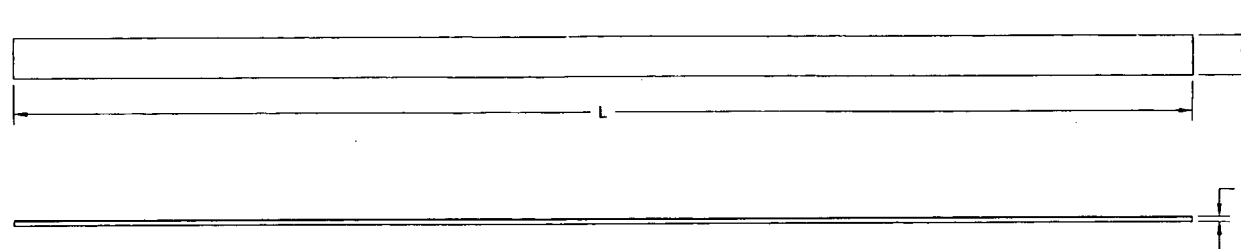
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# SPECIFICATION CONTROL DRAWING



## D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

△B

83104

**RELEASED**  
2009-12-02

- NOTES:
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE TABLE

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3937	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
DATE	09.11.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

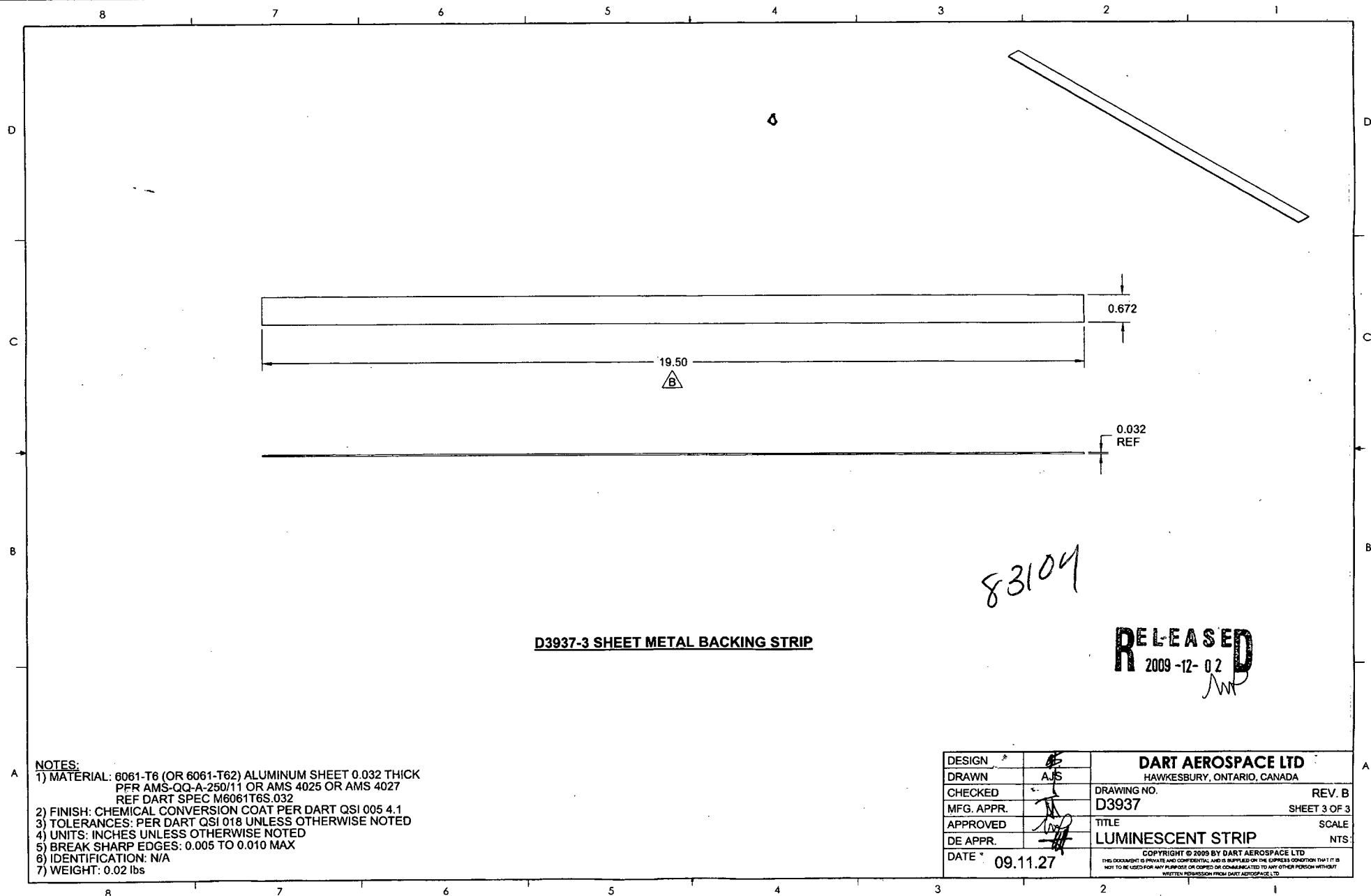
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3937-3 SHEET METAL BACKING STRIP**

**RELEASED**  
2009-12-02

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3937	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries